

Date: Friday, 03/04/2009 10:19:28 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL TUNNEL R/H
Job Number : 46913	
Estimate Number : 13586	
P.O. Number :	Part Number : D38222
This Issue : 03/04/2009 S.O. No. :	Drawing Number : D3822 PRELIMINARY
Prsht Rev. : NC	Project Number : IN0002
First Issue : / / Type : THERMOFORMING	Drawing Revision : B PRELIMINAY
Previous Run : 44458	Material : MKYD6185S080P362015
Written By :	Due Date : 10/04/2009 Qty: 2 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est. A New Issue 08/09/17 DL Rev B Dwg. Update 09/02/09 DL verified by:DD	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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Comment: Qty.: 7.4028 sf(s)/Unit Total : 14.8056 sf(s)
 6185 Kydex .080"

M109703

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/04/03. (2)

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/04/03. (2)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-2and folio FTA 026 using tool DT 9074

Dwg. Rev. B
 Folio Rev. _____

BB 09/04/03. (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 03/04/2009 10:19:28 AM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL R/H

Job Number: 46913

Part Number: D38222

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

P10 →
BB 09/04/03 X3

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09/04/06 (2)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/04/03 X2

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances

BB 09/04/06 X2

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/06 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

POSITIVE RECALL

EFFECTIVE 09/04/03 AUTH h
RELEASED PH DATE 09/04/14

09/04/15 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



09/04/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3822-2 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 09/04/15
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46913</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/15	S.O	TRIMMING ERROR WHEN DEMOUNTING knife slipped. RC: Human error.	<u>OS142</u>	Scrap & replace Qty 1 use to fit & use in A/C Eng use only & Identify.	<u>BB</u> 09/04/15	<u>09/04/15</u>	<u>OS142</u>	<u>09/04/15</u>

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 46913
Description:	Part Number: D3822-2
Inspection Dwg: D3822 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype Prelim.

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/04/06.

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.040	MIN	.050	✓			
.040	MIN	.0475	✓			
.040	MIN	.042	✓			
.030	MIN	.038	✓			
1.2		1.25	✓			
.8	Min	.925	✓			
.55	Min	.875	✓			

Measured by: BB

Date: 09/04/06.

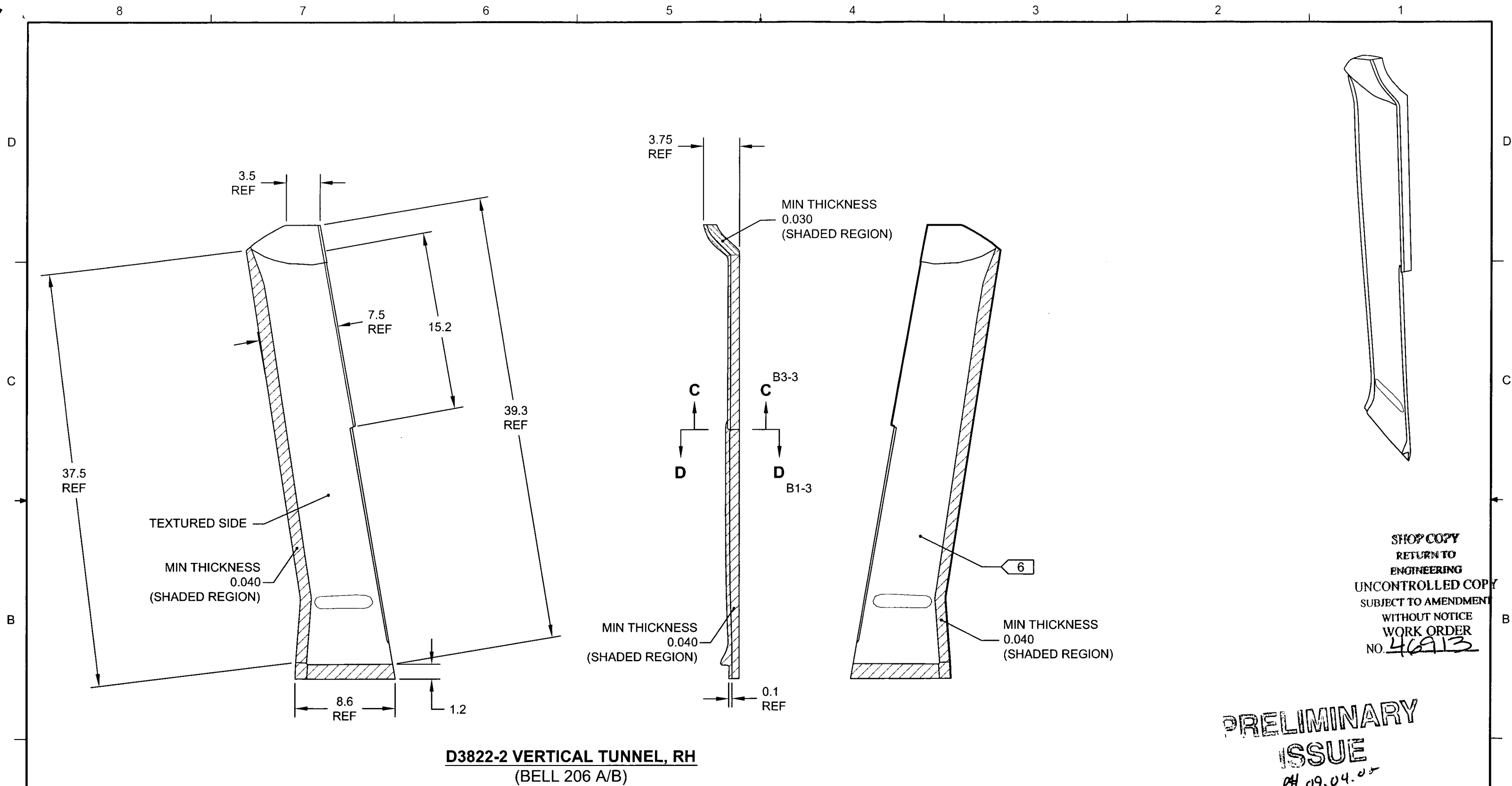
Audited by: [Signature]

Date: 09.04.06

Prototype Approval:

Date:

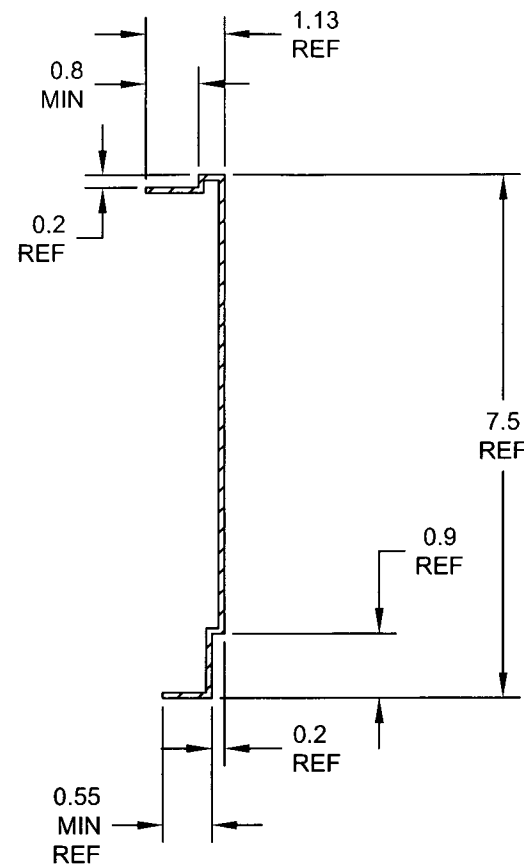
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



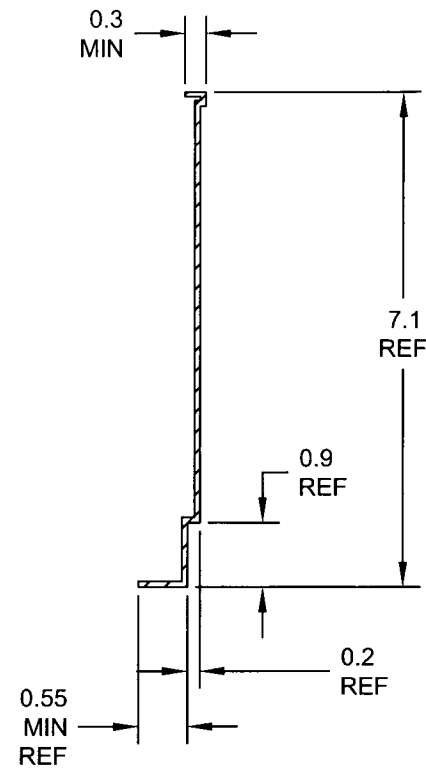
NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9074 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

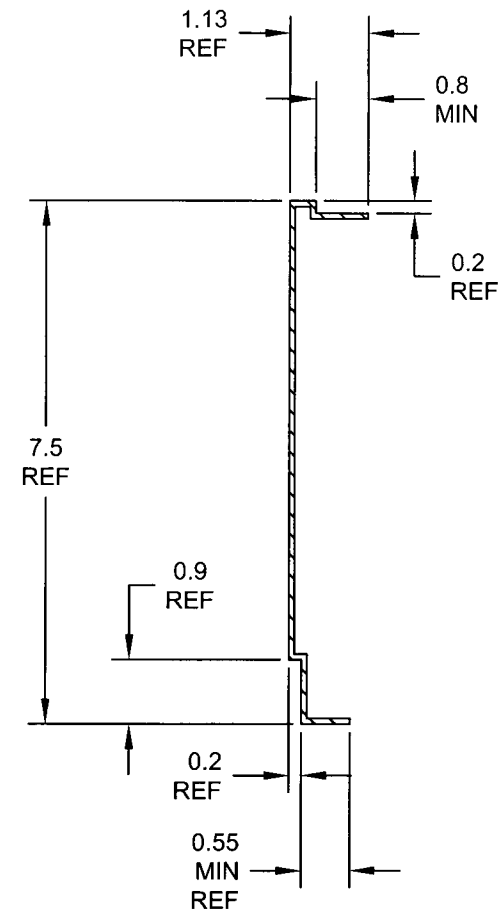
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DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3822	SHEET 2 OF 6
APPROVED		TITLE	SCALE
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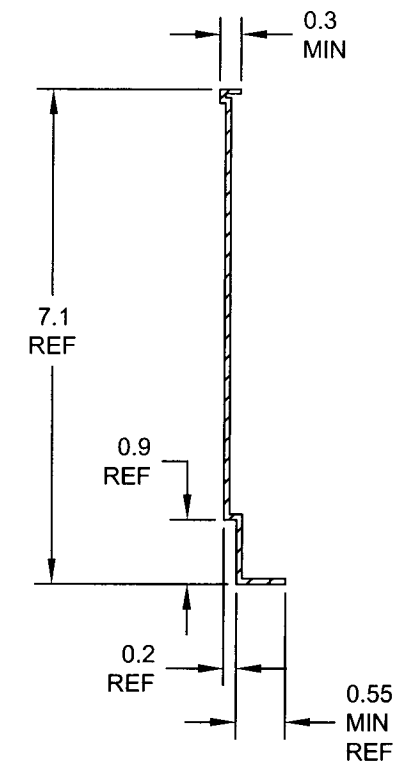
SECTION A-A C6-1



SECTION B-B C6-1



SECTION C-C C4-2



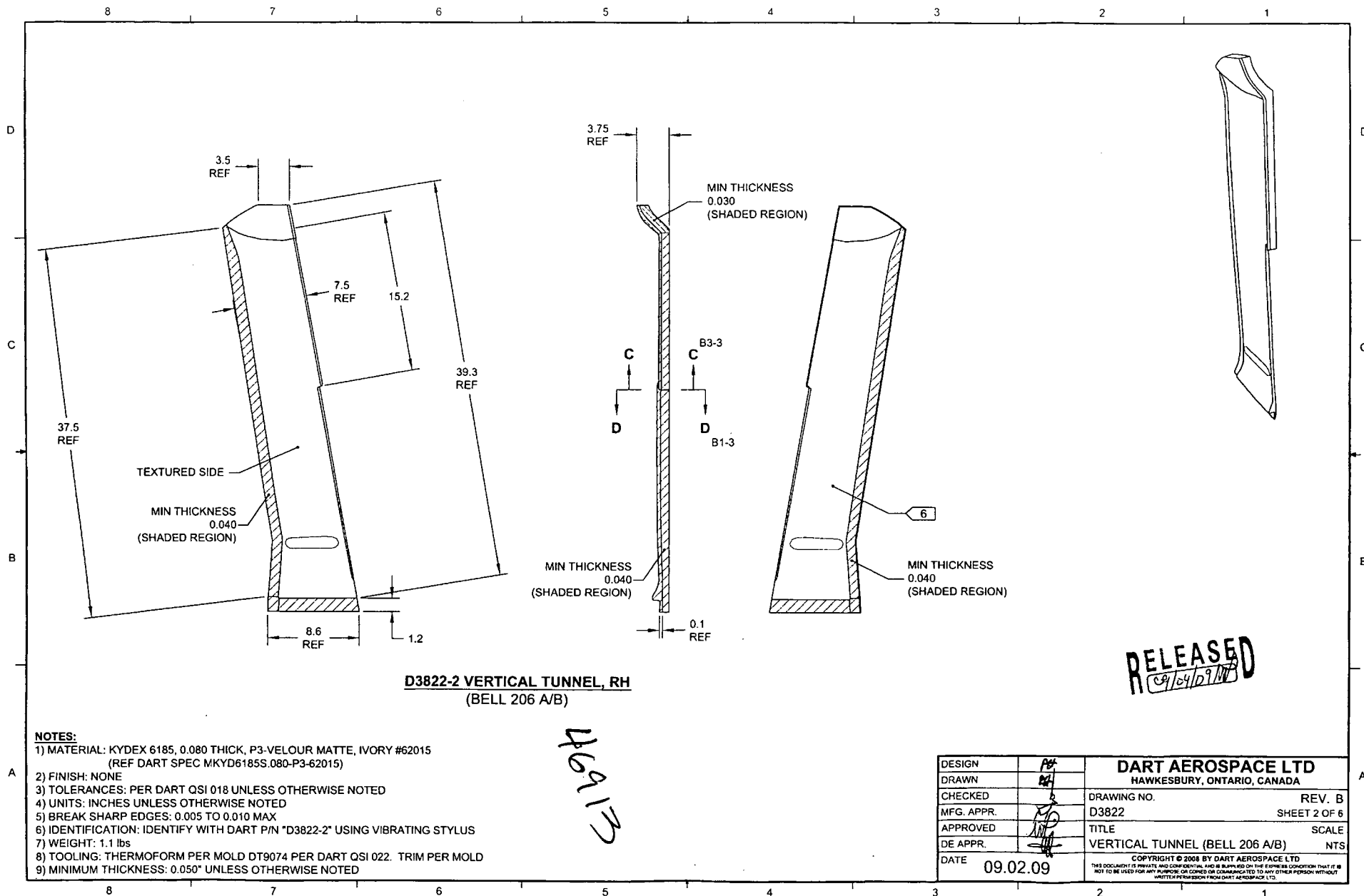
SECTION D-D C4-2

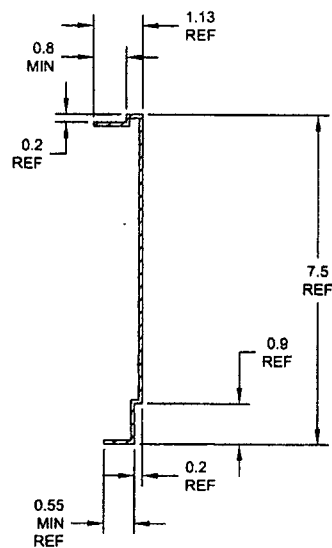
**PRELIMINARY
ISSUE**

PH 09.04.02

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46913

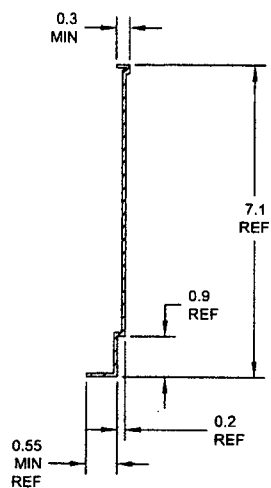
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MFG. APPR.		D3822	SHEET 3 OF 6
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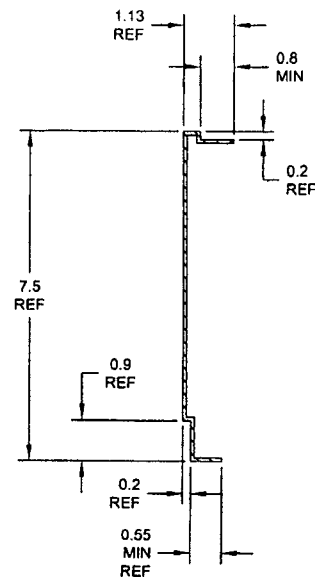
SECTION A-A

C6-1



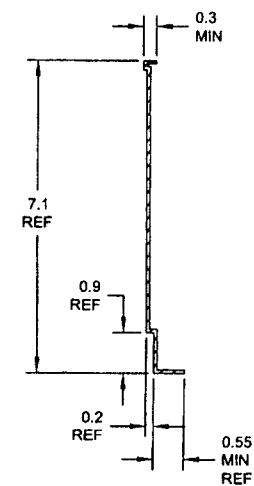
SECTION B-B

C6-1



SECTION C-C

C4-2



SECTION D-D

C4-2

46913

RELEASED
C101121W

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DRAWN	PE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PE	DRAWING NO.	REV. B
MFG. APPR.	PE	D3822	SHEET 3 OF 6
APPROVED	PE	TITLE	SCALE
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